

Date: Wednesday, 12/11/2008 1:37:15 PM
User: Julie Dawson

Process Sheet

| | | | | | | | |
|-----------------------|--|----------|----------------|------------------|-------------------------------|--|--|
| Customer | CU-DAR001 Dart Helicopters Services | | | Drawing Name | : BRACKET | | |
| Job Number | 43353 | | | Part Number | : D3637041 | | |
| Estimate Number | 12966 | | | Drawing Number | : D3637 REV B | | |
| P.O. Number | : | | | Project Number | : N/A | | |
| This Issue | 12/11/2008 | S.O. No. | : | Drawing Revision | : B | | |
| Prsht Rev. | NC | | | Material | : | | |
| First Issue | / / | Type | SMALL /MED FAB | Due Date | : 21/11/2008 Qty: 20 Um: Each | | |
| Previous Run | 42994 | | | | | | |
| Written By | | | | | | | |
| Checked & Approved By | <u>JLJ 08.11.12</u> | | | | | | |
| Comment | Est Rev:A New Issue 07-07-20 JLM Verified By:EC Est Rev:B change to REV.B as per dwg 08-02-11 DD verified by:ec | | | | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|---|--|
| 1.0 | M304S14GA | 304SS sheet .080 |
| | | |
| | Comment: Qty.: 0.0945 sf(s)/Unit Total : 1.8900 sf(s) 304SS .080 Batch: <u>109358</u> HB 8-11-17 | |
| 2.0 | WATER JET | FLOW WATER JET |
| | | |
| | Comment: FLOW WATER JET 1-Cut as per Dwg D3637 Dwg Rev: <u>B</u> HB 8-11-17 Prog Rev: <u>B</u> | (36) |
| | 2-Deburr if necessary HB 8-11-17 | |
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
| | | |
| | Comment: INSPECT PARTS AS THEY COME OFF MACHINE HB 8-11-17 | |
| 4.0 | QC8 | SECOND CHECK |
| | | |
| | Comment: SECOND CHECK | counter S 08/11/18 +36 |
| 5.0 | BRAKE NC | NC BRAKE |
| | | |
| | Comment: NC BRAKE Form as per Dwg D3637 | S 08/11/18 (36) |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 12/11/2008 1:37:15 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 43353

Part Number: D3637041

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 MS21059L4

Nutplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s) - 3

Nutplate

BATCH: M106322

FF 08/12/02

7.0 MS20426AD33

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 40.0000 Each(s) - 6

Rivet

BATCH: M1563

FF 08/12/02

8.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- drill holes as per dwg using DT8979

2-C'Sink as per Dwg D3637

3-Install Nut plate as per Dwg D3637

P10

08/12/02

counter

22x

9.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/12/05

22

10.0 PACKAGING 1

PACKAGING RESOURCE #1



22x

SP

Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: 261

8/12/05

11.0 QC21

FINAL INSPECTION/W/O RELEASE



08/12/08 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-12-08

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: D3637-041 PAR #: N/A Fault Category: *Eng. Coordinate* Prod / ~~Part not met~~ NCR: Yes No DQA: *S* Date: 08/12/09

Resolution: *Scrap* Disposition: *Scrap* QA: N/C Closed: *S* Date: 08/12/09

| NCR: 43353 | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------------|------|---|-----------------------------|--|------------------------------|------------------------------|------------------------------|------------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 08/12/09 | 8.1 | 14 parts are scrap. 1 hole on each part, @ the 0.600" from the edge dimension, is 0.030" too far in resulting in a 0.630 hole dim. R.C: Incorrect hole dimension on the drill sig. | <i>8.1</i> | - Scrap all 14 parts & no replace. - Fill in the holes that are affected on the DT8979 drill sig with magna bond, so they can not be used. Drill one side of the part, flip it, and drill the other side. | <i>EP</i> <i>08/12/09</i> | <i>EP</i> <i>08/12/09</i> | <i>EP</i> <i>08/12/09</i> | <i>EP</i> <i>08/12/09</i> |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | | |
|-----------------------|--------------|--------|
| DART AEROSPACE LTD | Work Order: | 433 |
| Description: Bracket | Part Number: | D363 |
| Inspection Dwg: D3637 | Rev: B | Page 1 |

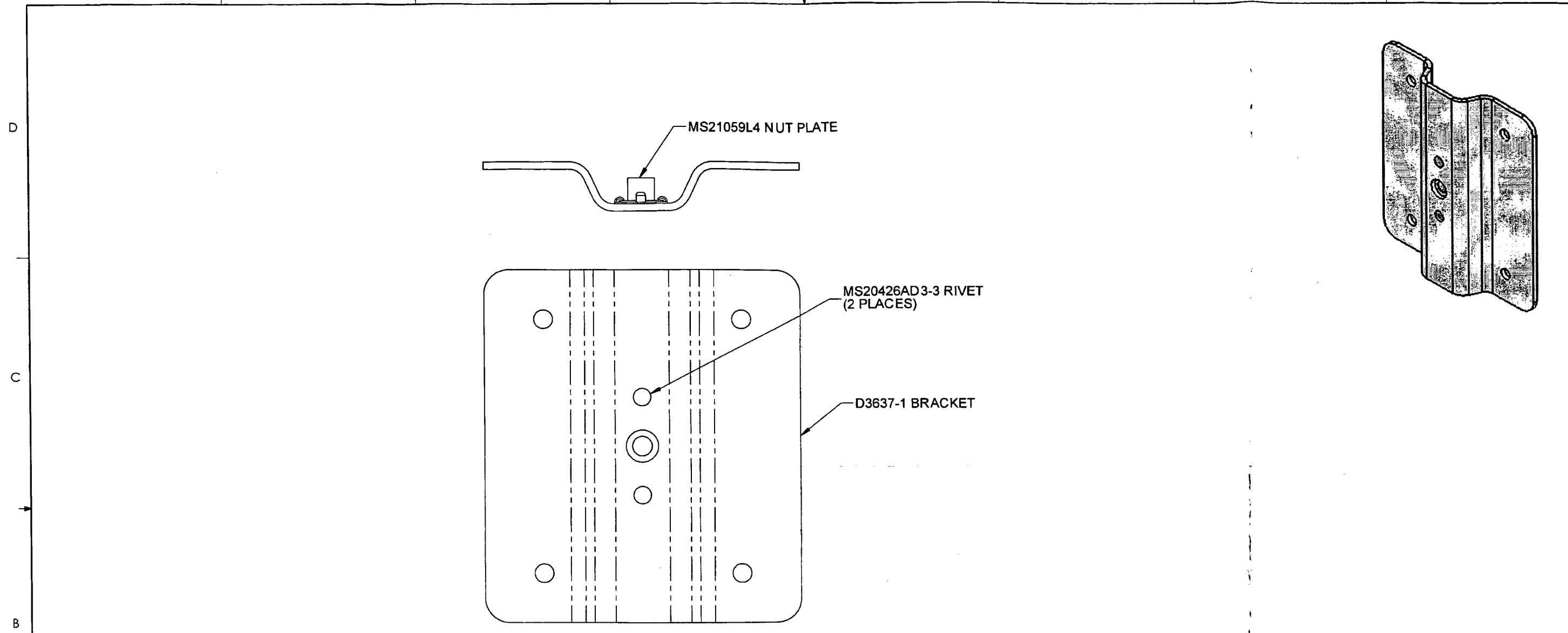
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

| | | | | | |
|--------------|----------|-------------|----------|---------------------|-----|
| Measured by: | <u>B</u> | Audited by: | <u>D</u> | Prototype Approval: | N/A |
| Date: | 8-11-17 | Date: | 06/11/19 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|------------|-------------|---------------|-------------------|---|
| A | 08.04.15 | New Issue | P/O D3637-041 | KJ/DD  |

8 7 6 5 4 3 2 1



**D3637-041 BRACKET ASSEMBLY
(WAS GENEVA P/N G10602-1)**

D3637-041 PARTS:

| QTY | P/N | DESCRIPTION |
|-----|--------------|------------------|
| X | D3637-041 | BRACKET ASSEMBLY |
| | | |
| 1 | D3637-1 | BRACKET |
| 1 | MS21059L4 | NUTPLATE |
| 2 | MS20426AD3-3 | RIVET |

D3637-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: N/A
- 4) UNITS: N/A
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.27 lbs

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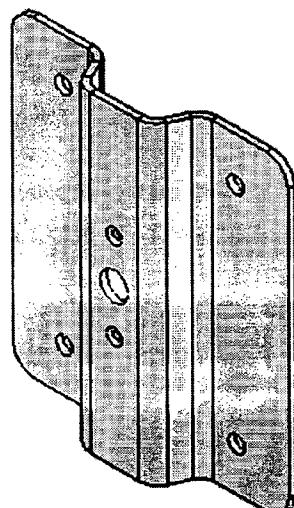
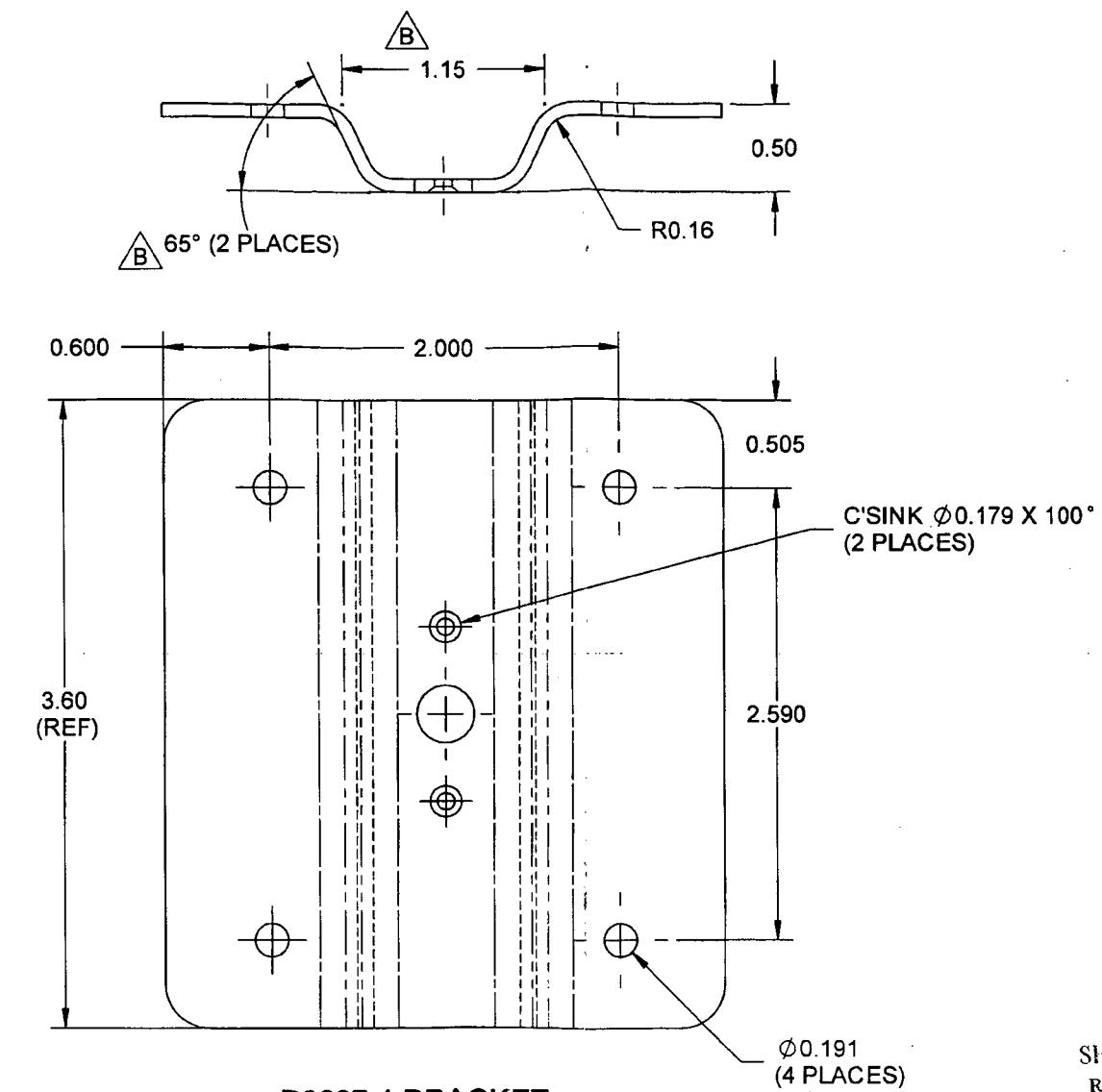
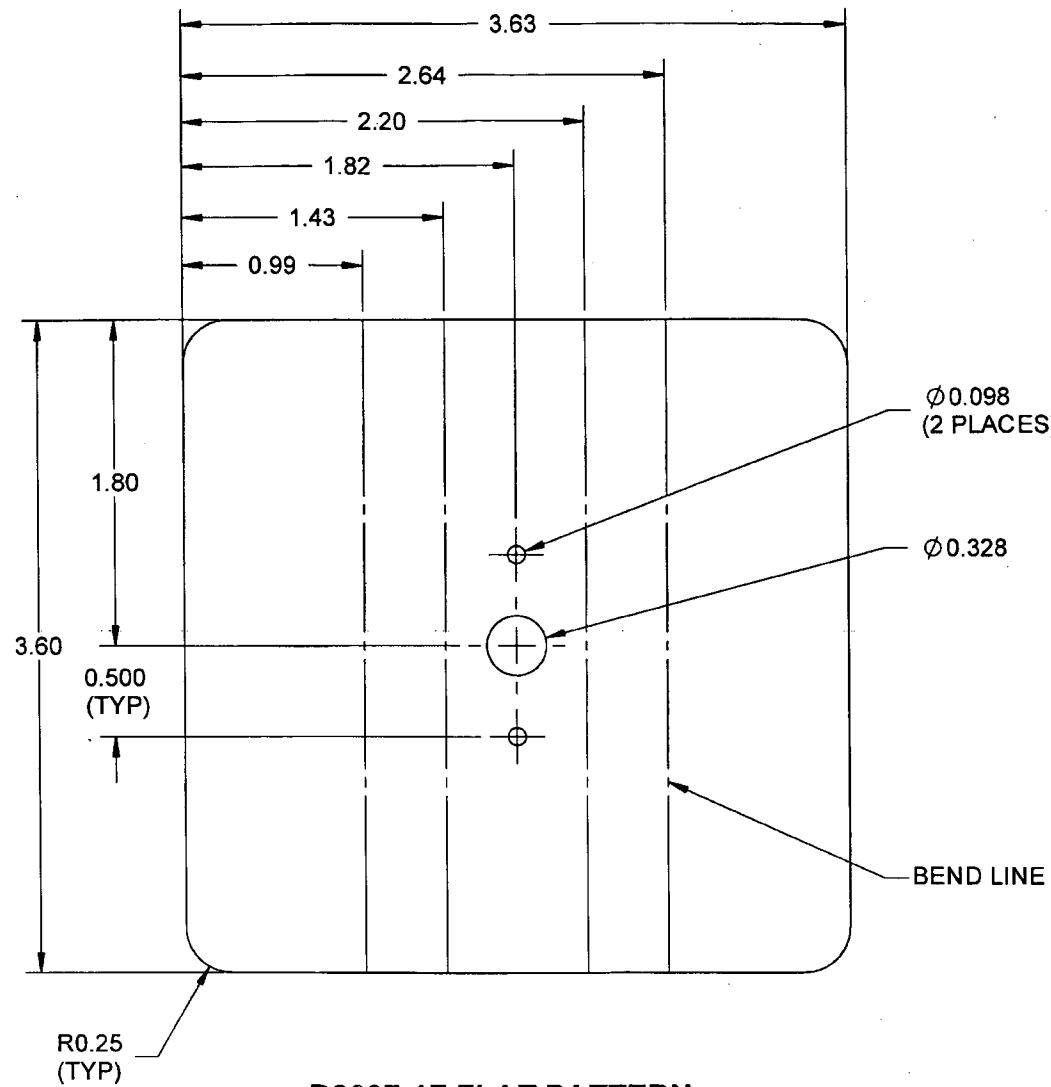
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WORK ORDER

NO. 43353

RELEASED BY [Signature] 26-02-05
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WITHOUT NOTICE WORK ORDER NO. 43353

| B | FOR D3637-1, 1 15 WAS 1.30 & "REF" REMOVED FROM ANGLE | LE | 07.12.18 |
|------------|---|---|--------------|
| A | NEW ISSUE; REPLACES G10608, G10602 & G10609 | LE | 07.07.27 |
| REV. | DESCRIPTION | | |
| DESIGN | TS | DART AEROSPACE LTD | |
| DRAWN | [Signature] | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | [Signature] | DRAWING NO. | REV. B |
| MFG. APPR. | [Signature] | D3637 | SHEET 1 OF 3 |
| APPROVED | [Signature] | TITLE | SCALE |
| DE APPR. | [Signature] | BRACKET | 1:1 |
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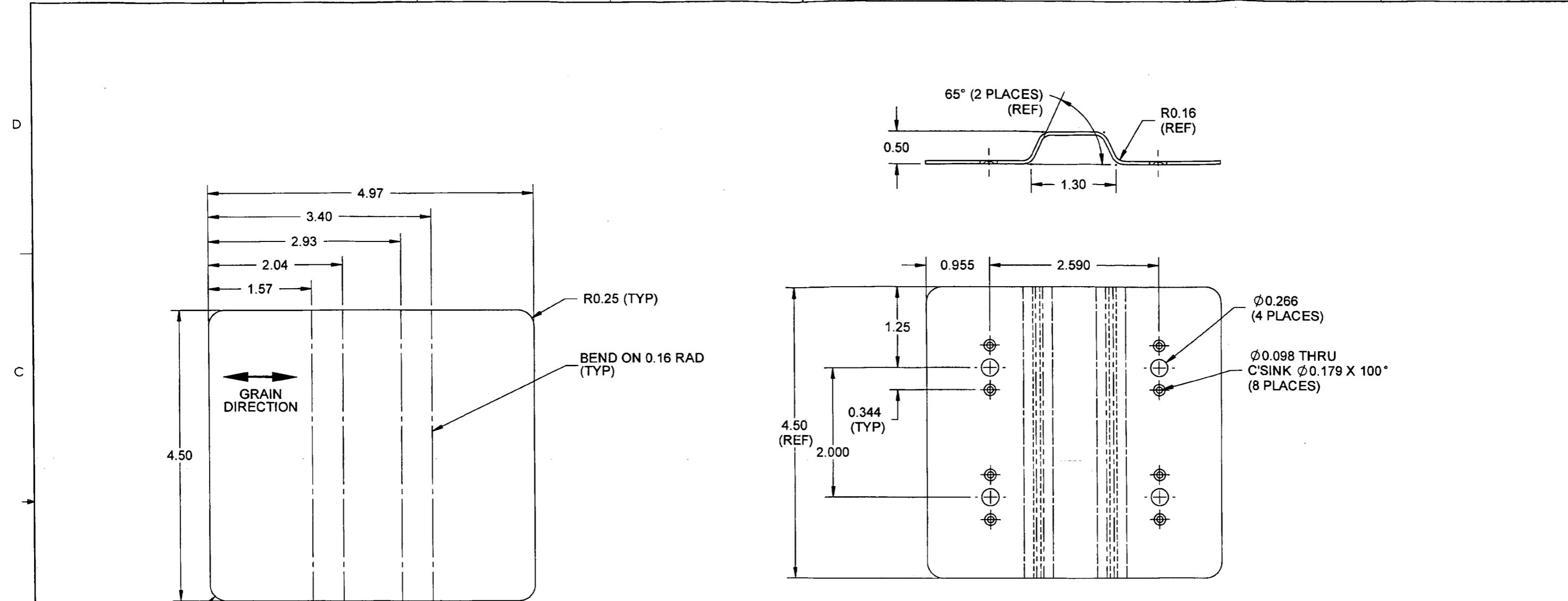
A
D3637-1 NOTES:
 1) MATERIAL: AISI 304/316 SS SHEET, 14 GAUGE PER MIL-S-5059
 (REF DART SPEC M304S14GA)
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE
 7) WEIGHT: 0.26 lbs

| | | |
|------------|----------|-----------------------------|
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| DRAWN | LE | HAWKESBURY, ONTARIO, CANADA |
| CHECKED | RE | DRAWING NO. |
| MFG. APPR. | LJ | REV. B |
| APPROVED | SP | SHEET 2 OF 3 |
| DE APPR. | SP | TITLE |
| DATE | 07.12.18 | SCALE |
| | | BRACKET |

RELEASED 043363
08.02.05 PM

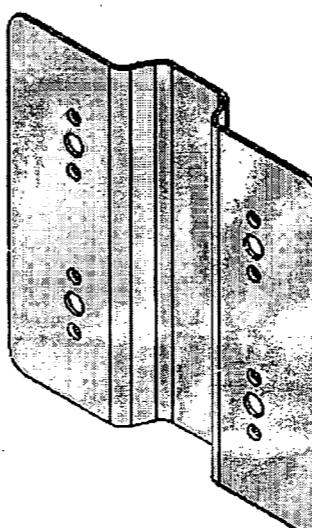
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8 7 6 5 4 3 2 1



D3637-3F FLAT PATTERN

D3637-3 BRACKET
(WAS GENEVA P/N G10609-1)



D3637-3 NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM 0.050 THICK PER QQ-A-250/4 OR AMS 4037
(REF DART SPEC M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-3" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.32 lbs

| | | |
|------------|--------------------|--|
| DESIGN | TS | DART AEROSPACE LTD |
| DRAWN | <i>[Signature]</i> | HAWKSLEY, ONTARIO, CANADA |
| CHECKED | <i>[Signature]</i> | DRAWING NO. |
| MFG. APPR. | <i>[Signature]</i> | REV. B |
| APPROVED | <i>[Signature]</i> | D3637 |
| DE APPR. | <i>[Signature]</i> | SHEET 3 OF 3 |
| DATE | 07.12.18 | SCALE |
| | | 2:3 |
| | | BRACKET |
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